

Date: Tuesday, 12/5/2006 8:20:47 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING
 Job Number : 29827
 Estimate Number : 10336
 P.O. Number : N/A Part Number : D2807
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2807 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C
 Previous Run : 28488 Material : N/A
 Written By : _____ Due Date : 1/5/2007 Qty: 40 Um: Each
 Checked & Approved By : JA 061205
 Comment : Est: D 05.06.21 Removed painting; Changed supplier
 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2642C20612106

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

(40)

2.0 SXF6S6050080S6L115N GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
 SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

PC 7/04/11

(40)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7-07-01-15

(40)

5.0 D28073 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: _____

47 x B29831
 x33 B28489

✓
ml 07/04/19 x80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/25

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:20:47 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 29827

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Install lugs and crimp using DT8791 crimp jig.
- 2-Remove lettering and logo with wash and wipe.

ml 07/04/19 x 40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

704-24 (40) counted

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5747*

12/4/24 (40)

9.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

ED 07/04/25 (40)

Job Completion



u 07-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

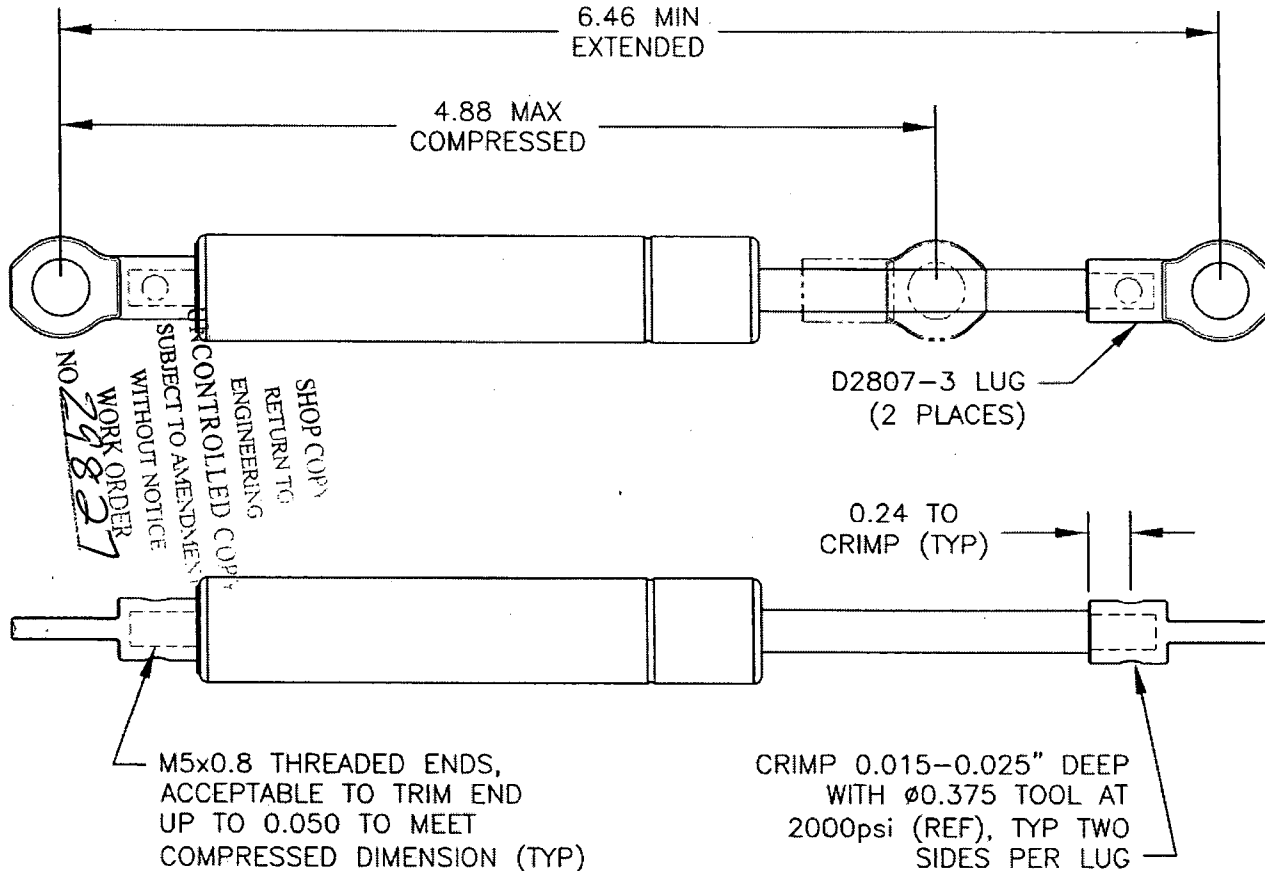
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
R# 05.06.16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.25	TITLE	D2807	REV. C
			GAS SPRING	SHEET 1 OF 2
				SCALE
				1:1
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		

**D2807 GAS SPRING**

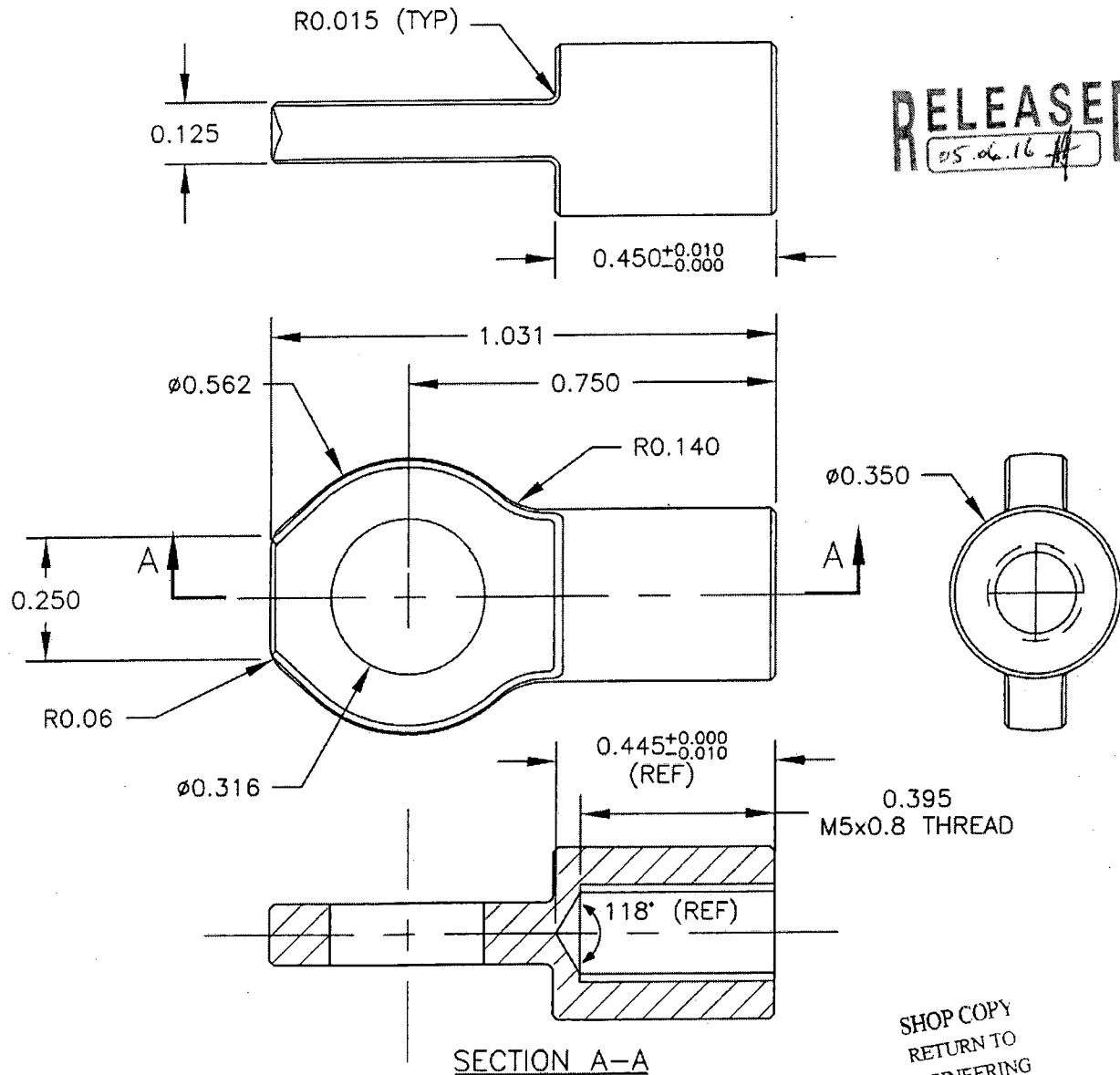
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29827

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ArvinMeritor™

59664/001

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HAWKESBURY, ONTARIO
K6A 1K7
CANADA

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HAWKESBURY, ONTARIO
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CANADA

OUR REF.

59664

DATE _____

050107

A/C No.

2011

AREA

46

~~CUSTOMER REF. No.~~

P000002642

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDER

NUMBER

[illegible]